

Date: Tuesday, 2/7/2006 12:13:07 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEARPLATE	
Job Number	: 25726		Part Number	: D33153	
Estimate Number	: 10747		Drawing Number	: D3315 REV. PRELIM.	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 2/7/2006 S.O. No. : N/A		Drawing Revision	: A-B 06.03.08	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 2/14/2006 Qty: 10 Um: Each	
Previous Run	: 24607				
Written By	: See COMMENT Below				
Checked & Approved By	: [Signature]				
Comment	: Est: A 05.05.12 New issue KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	PG	PURCHASING
		 Comment: PURCHASING Issue P/O: 00000521 <i>Al 06/02/06</i> Email or Ship DXF file to vendor Laser Cut flat pattern per Dwg D3315 Possible Supplier: Industrial Laser Material release note is required
2.0	D33153F	Wearplate, LH Center
		 Comment: Qty.: 1.0000 U(s)/Unit Total: 10.0000 U(s) WEARPLATE
3.0	PACKAGING 1	PACKAGING RESOURCE #1
		 Comment: PACKAGING RESOURCE #1 Recieve & Inspect for Transit Damage Ensure Material Release Note is attached
4.0	QC6	DIMENSIONAL CHECK
		 Comment: DIMENSIONAL CHECK Inspect dimensions as per inspection template D3315-3T1
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		 Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/7/2006 12:13:07 PM
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Job Number:



Seq. #: Machine Or Operation: Description :

6.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1- Form using DT8179 Die and DT8157 as per Dwg D3315 Rev: B

B 06.03.08 (5)

7.0 QC6 DIMENSIONAL CHECK



J 06.03.07

Comment: DIMENSIONAL CHECK

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3315-3T3 as per QSI 004 and Dwg D3315 Rev: B

Qty Part Number Description Batch
A/R N/A 7560 Hardcoat Rod M19682

CPC 06.03.15

P10

(5)

9.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 06/03/16

(4)

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

DL 06/03/20

(4)

11.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M 06.03.21

(4)

12.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3315-3, B/N: BXXXXX

For Product Eligibility see PDA04-17

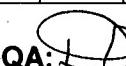
and Stock

PDA05-17 PH 06.03.09

Location:

L 06/03/21 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06-03-14	8	Took 1x D3315-3 wearplate to make D3315-3TB Welding Template Inspected by: Jm 06-03-14	QCL	06-03-14	1	 06-03-14	 06-03-14

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/03/22
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 2/7/2006 12:13:07 PM
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Drawing Name: WEARPLATE

Job Number: 25726

Part Number: D33153

Job Number:



Seq. #: Machine Or Operation:

Description :

13.0

DC

DOCUMENT CONTROL



(4)

Comment: DOCUMENT CONTROL

Inspection Level 21

LJ 06/03/22

u Dec 3, 22

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92141, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 236 8089 / 235 3535 Waiuku
Fax: (09) 375 8959

TEST CERTIFICATE

Ref: 559724541

P.0521

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (B)=50mm	PLASTIC STRAIN RATIO (r) (A)=r0 (B)=r90 (C)=80mm (D)=(r0+r90+2r45) / 4 (E)=2" (F)=6"	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm (C)=5mm x 5mm (D)=2.5mm x 10mm (E)=6mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
--	--	--	---	---

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED Satish Misra
OC METALLURGIST



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephone: (09) 375 8999 / 375 8111 Auckland
(09) 235 8089 / 235 3535 Waiuku
Fax: (09) 375 8999

TEST CERTIFICATE

Ref: 5746/25194

Reissued 1/12/2005

CUSTOMER		Wilkinson		SPECIFICATION ASTMA1008 CS Type A												CERTIFICATE No TC122435						
CUSTOMER Q/N		99-21N-963		PRODUCT CRA WIDE COIL												PAGE	1 of 1					
MILL Q/N		507683		DIMENSIONS 0.114" x 48" x Coil												DATE	29 November 2005					
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT												MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)								
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND 180°	YIELD 180°	T.S. G.L.=	%ELONG G.L.=	HARDNESS HRB
		x100			x1000					x10000			x100									
R9-471775-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1			Good			51		794	
R9-471776-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1			Good			51		682	
R9-471777-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1			Good			54		768	
R9-471778-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1			Good			54		640	

YIELD (A)=0.2% PROOF STRESS (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65, So (F)=8"	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65, So (F)=8"	PLASTIC STRAIN RATIO (r) (A)=r0 (C)=r45 (B)=r90 (D)=(r0+r90+2r45)/4	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
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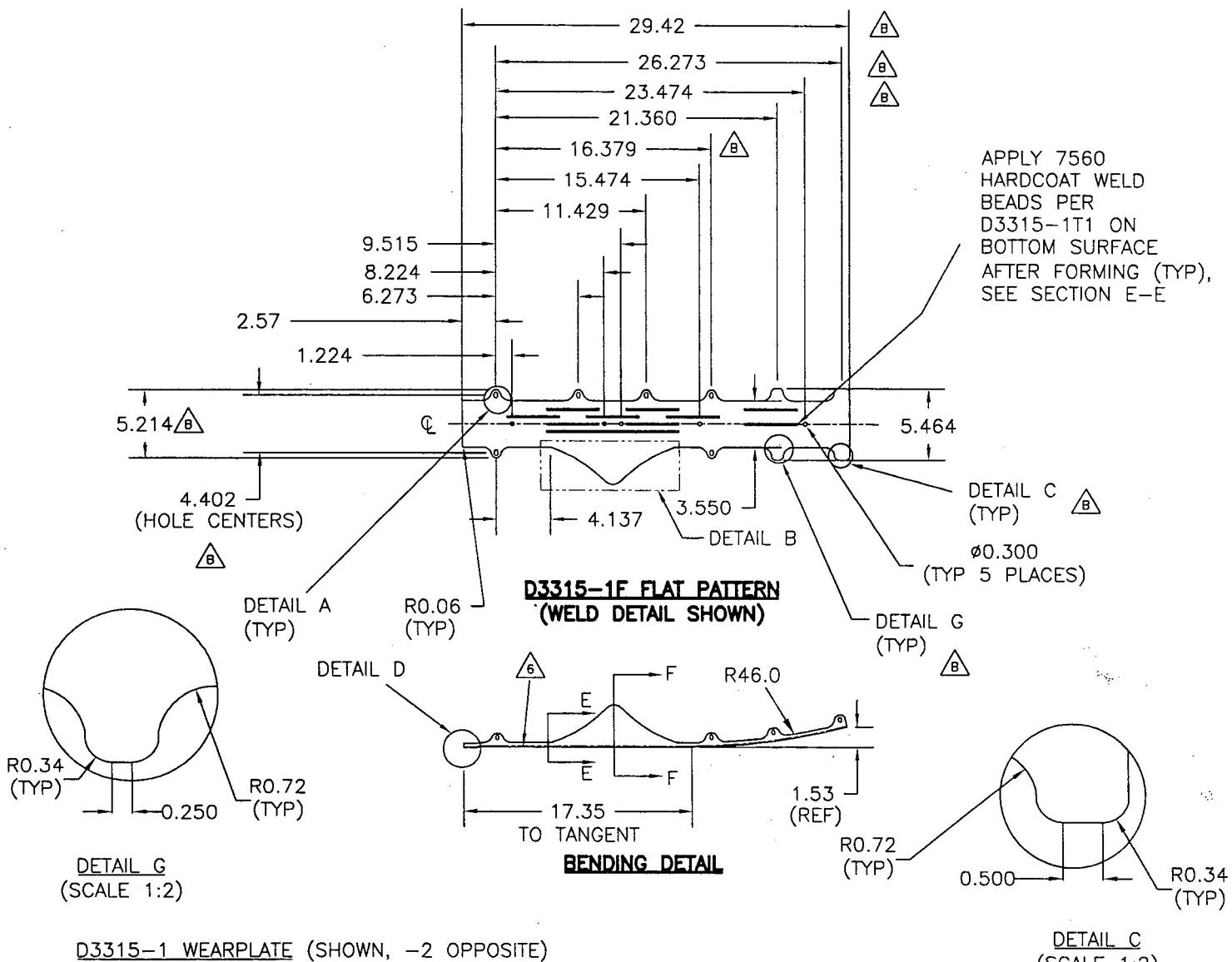
WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Batish Misra*
QC METALLURGIST

PROTOTYPE

PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

J5.03.22 PT



DESIGN	DRAWN BY	DART AEROSPACE LTD		
CHECKED	APPROVED	DRAWING NO.	HAWKESBURY, ONTARIO, CANADA	
		D3315	DATE	REV. B
A 06.01.31	04.09.10	NEW ISSUE	TITLE	SHEET 1 OF 4
B 06.01.31	06.01.31	WEARPLATE	SCALE	1:12

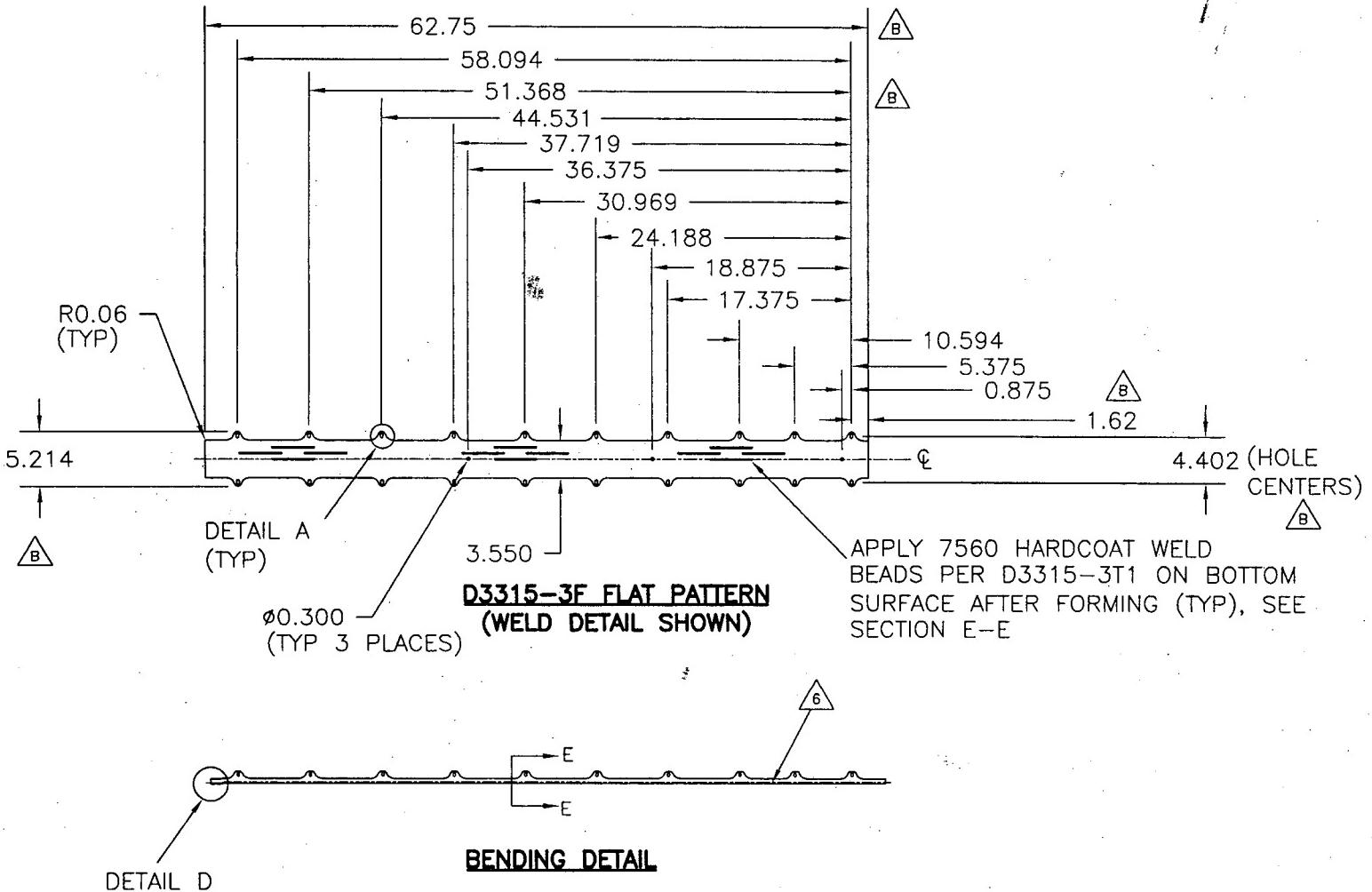
D3315-1 WEARPLATE (SHOWN, -2 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-1.7"

PROTOTYPE

PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING

~~06 C7 27 PDA~~



BENDING DETAIL

D3315-3 WEARPLATE (SHOWN, -4 OPPOSITE)

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 16 GAUGE (0.060 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3315-X
B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-17"

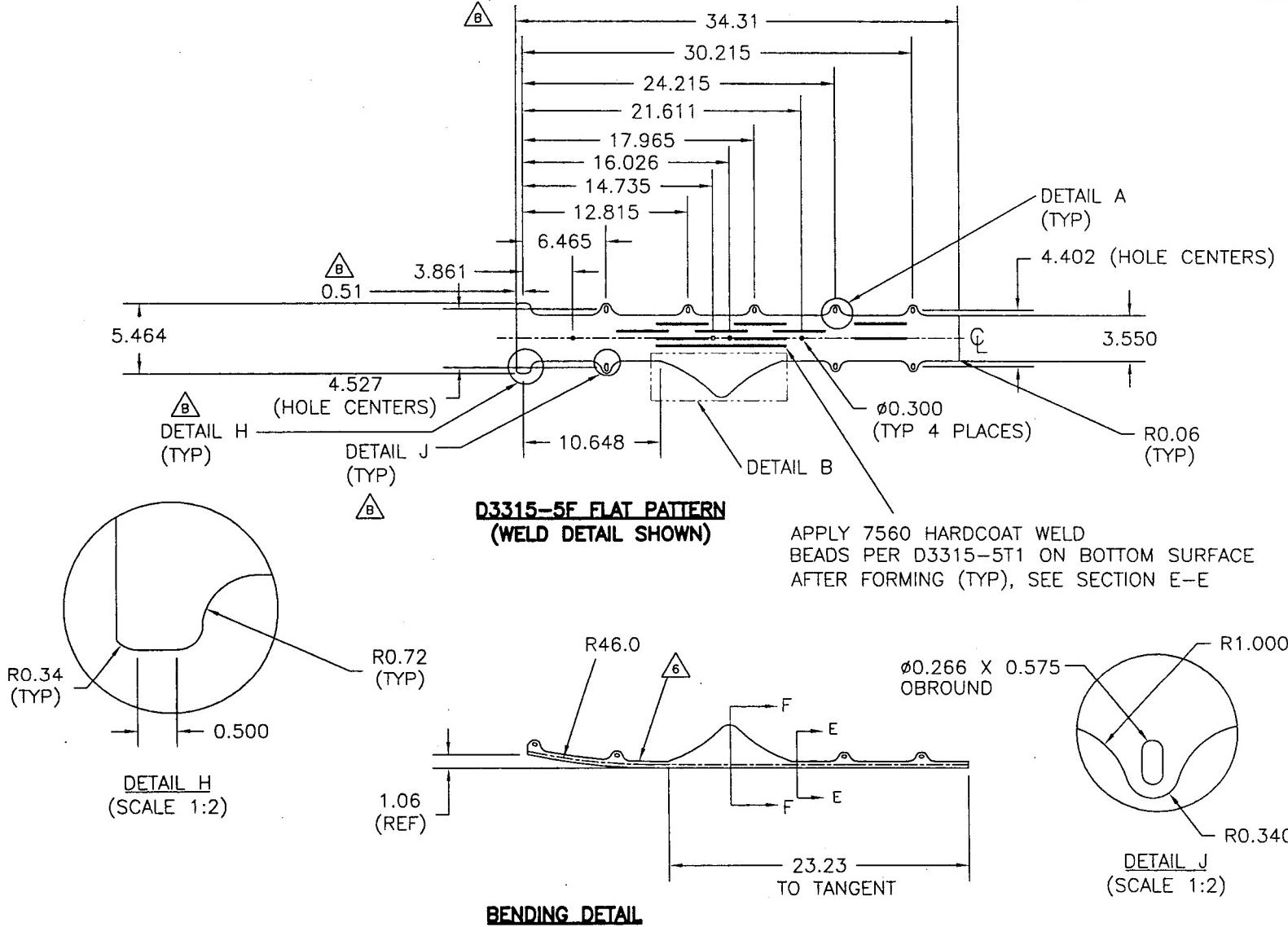
DESIGN CHECKED	DRAWN BY APPROVED	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DATE	DRAWING NO.	REV. B
06.01.31	D3315	SHEET 2 OF 4
	TITLE WEARPLATE	SCALE 1:16

PROTOTYPE

PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
06.02.37 R4

06.02.37	R4
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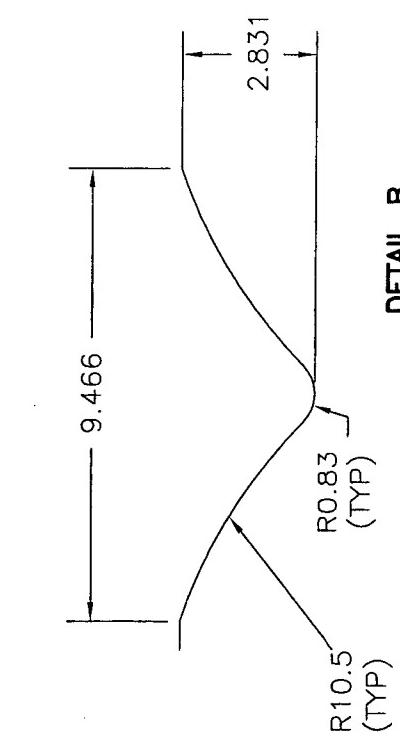
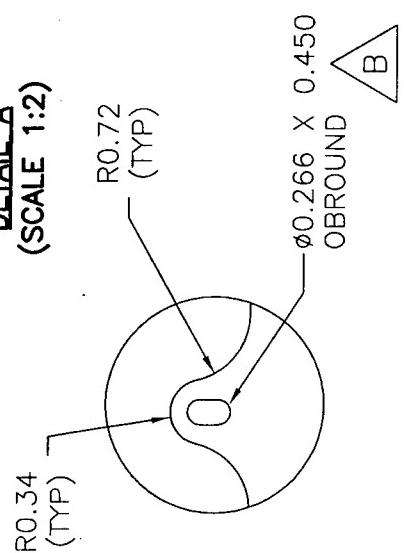
DESIGN	DRAWN BY	DART AEROSPACE LTD	
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA	REV. B
DATE	TITLE	DRAWING NO.	SHEET 3 OF 4
06.01.31	WEARPLATE	D3315	1:12



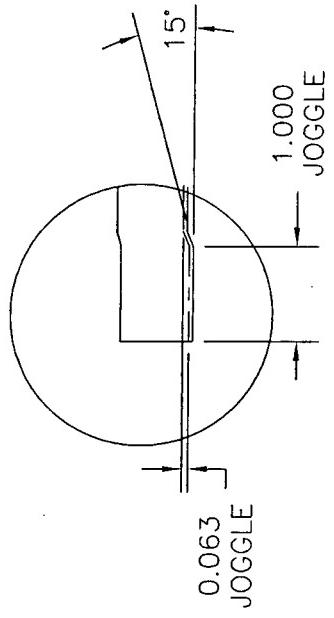
PROTOTYPE
PLEASE RETURN ALL ISSUED
DATA TO ENGINEERING
05.02.27 PH

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
DATE	06.01.31	TITLE	SHEET 4 OF 4 WEARPLATE

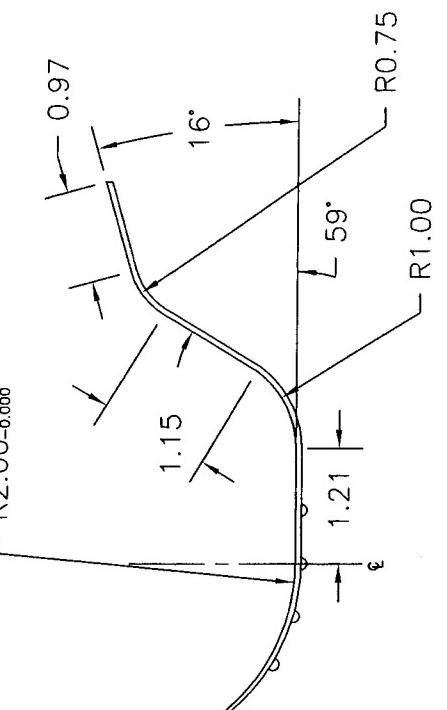
DETAIL A
(SCALE 1:2)



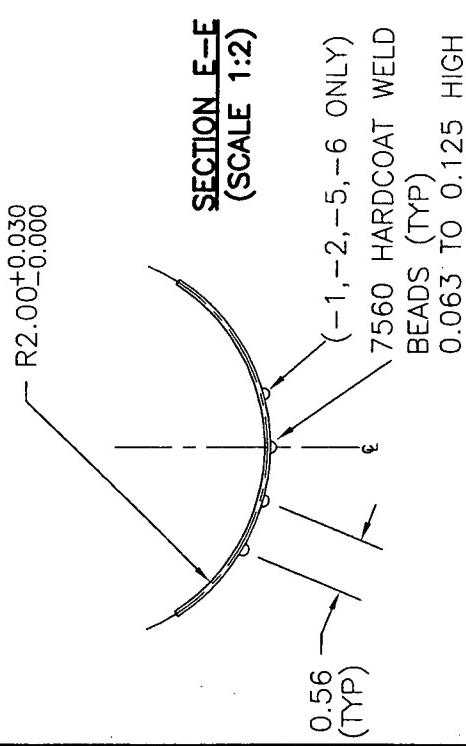
DETAIL B
(SCALE 1:4)



DETAIL D
(SCALE 1:2)



SECTION F-F
(SCALE 1:2)



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